

Work Order ID 73485

Thursday, September 01, 2011 10:49:25 AM



Ship Sept 13th

Page 1

Item ID: D350-600-249

Accept



Setup Start



Revision ID:

Item Name: Spacepod Upgrade

Stop



Start Date: 9/1/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 9/5/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: mk Date: 11-08-01

Tooling: _____ Date: _____

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
N/A	Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP 350-600-249 CHG001

S. V. 10/1/11

110

0.00



Packaging

Packaging

Memo

0.00

Packaging

Packaging

PO 9/6 (12)

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

S. V. 10/1/11

(72)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73485

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Item ID: D350-600-249

Accept

Revision ID:

Item Name: Spacepod Upgrade

Start Date: 9/1/2011 Start Qty: 12.00

Required Date: 9/5/2011 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

0.00

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-600-249

Location: B

PPP Rev: _____

11/9/11 1451/10

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/9/11 1451/10
MF 11-09-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 73485

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade



Start Date: 9/1/2011

Required Date: 9/5/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A new issue 07.01.31 EC
11.02.07 added missing AN960JD8 washer DD
verf:JLM
REV:A 11.04.27 added 1 D3554-7 DD verf:EC

IPP Rev:B

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

A3235-020-935

Purchased

No

120

Each

342.0000

1

12



Washer - Countersunk

Location

Loc Qty

Loc Code

ST281

342

106150

342

106150

AN526C832R10

Purchased

No

120

Each

57.0000

10

120



Screw

Location

Loc Qty

Loc Code

ST327

57

115101

57

115101 52

AN526C832R14

Purchased

No

120

Each

498.0000

6

72



Screw

Location

Loc Qty

Loc Code

ST327

498

104916

498

104916 6210

AN526C832R24

Purchased

No

110

Each

37.0000

4

48



screw

Location

Loc Qty

Loc Code

ST327

37

116556

37

116556 3710

115101 52
104916 6210
116556 3710

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 73485

Parent Item: D350-600-249


Parent Item Name: Spacepod Upgrade

Start Date: 9/1/2011

Required Date: 9/5/2011

Start Qty: 12.00

Required Qty: 12.00

AN5-5A	Purchased	No	120	Each	70.0000	1	12	
								
<i>S₄12</i> Bolt								


Location Loc Qty Loc Code


ST337


70


110865


70

AN960JD10	NAS1149D0363J	Purchased	No	120	Each	0.0000	1	12
								
<i>S₄12</i> Washer								

AN960JD10L	NAS1149D0332J	Purchased	No	120	Each	0.0000	1	12
								
<i>S₄12</i> Washer								

AN960JD516	NAS1149D0563J	Purchased	No	120	Each	0.0000	4	48
								
<i>S₄12</i> Washer								

AN960JD8	NAS1149DN832J	Purchased	No	120	Each	0.0000	24	288
								
<i>S₄12</i> Washer								

D2228		Manufactured	No	120	Each	19.0000	2	24
								
<i>S₄12</i> Bracket Plate								

Location Loc Qty Loc Code

ST009

19

64427

19

110865
118077
117087
118206
117887
B 73300 ST
64427 164

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 73485

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade

Start Date: 9/1/2011

Required Date: 9/5/2011

Start Qty: 12.00

Required Qty: 12.00

D2237

Manufactured

No

120

Each

23.0000

1

12



Striker Plate



11X B 73702

Location

Loc Qty

Loc Code

ST009

23

66139

3

70558

20

D2464

Manufactured

No

120

f

340.0000

3



3/4 Seal



70558 14

37.89474

37.89474

Location

Loc Qty

Loc Code

ST404

340

61878

340

(D2464-0360) cut (1) at 36.00 per kit

D3015-3

Manufactured

No

120

Each

172.0000

2

24



Locknut



Location

Loc Qty

Loc Code

ST030

172

66114

124

67536

48

D3538-1

Manufactured

No

120

Each

5.0000

2

24



Hinge Bracket



Location

Loc Qty

Loc Code

ST066

5

68505

5

66114

24

B733M194

68505 50

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 73485

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade

Start Date: 9/1/2011

Required Date: 9/5/2011

Start Qty: 12.00

Required Qty: 12.00

D3547-1

Manufactured No

120

Each

14.0000

1

12



Bracket

Location

Loc Qty

Loc Code

ST066

14

67604

14

67604

D3550-1

Manufactured No

120

Each

19.0000

1

12



Strut

Location

Loc Qty

Loc Code

ST271

19

66019

7

69040

12

66019 7X
69040 5X

D3552-7

Manufactured No

120

Each

8.0000

1

12



Door Prop

Location

Loc Qty

Loc Code

ST272

8

66012

3

68506

5

66012 3X
68506 5X

D3554-7

Manufactured No

120

Each

16.0000

2

24



Ball Stud

Location

Loc Qty

Loc Code

ST067

16

65123

7

69496

9

65123 7X
69496 9X

373382 4X

373383 8X 10/1/12 (12)

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 73485

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade

Start Date: 9/1/2011

Required Date: 9/5/2011

Start Qty: 12.00

Required Qty: 12.00

D3557-1

Manufactured No

120

Each

3.0000

1

12



Bracket



73384 76

[Signature]

Location

Loc Qty

Loc Code

ST067

3

64452

3

MS20426AD4-5

Purchased No

120

Each

5,368.000

2

24



Rivet



64452 34

[Signature]

Location

Loc Qty

Loc Code

MEZZ

193

6733

193

ST317

5175

6874

5175

MS21042L08

Purchased No

120

Each

602.0000

22

264



Nut



6874

[Signature]

Location

Loc Qty

Loc Code

ST300

602

117739

8

118451

100

118628

494

MS21042L3

Purchased No

120

Each

1,749.000

2

24



Nut



118628

[Signature] 11/9/6 (12)

Location

Loc Qty

Loc Code

ST300

1749

117441

132

117601

400

117885

217

118451

1000

117441

Thursday, September 01, 2011 10:49:18 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 73485



Parent Item: D350-600-249



Parent Item Name: Spacepod Upgrade

Start Date: 9/1/2011

Required Date: 9/5/2011

Start Qty: 12.00

Required Qty: 12.00

NAS1515H3

Purchased

No

120

Each

224.0000

2

24



Washer



21/9/6 (12)

Location

Loc Qty

Loc Code

ST277

224

116373

6

117460

56

118078

6

118384

156

117460

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
X									D350-600-241	SPACEPOD™ LH, AS350
	X								D350-600-242	SPACEPOD™ RH, AS350/355
		X							D355-600-243	SPACEPOD™ LH, AS355
1		1	X						D350-600-245	DOOR ASSEMBLY LH
	1			X					D350-600-246	DOOR ASSEMBLY RH
					X				D350-600-247	SPACEPOD™ UPGRADE KIT LH
						X			D350-600-248	SPACEPOD™ UPGRADE KIT RH
							X		D350-600-249	SPACEPOD™ UPGRADE KIT
1	1	1						X	D350-600-449	SWITCH RELOCATION KIT
2	2	2							D2174-041	WEB ASSEMBLY
							1		D2464-0360	NEOPRENE SEAL
			1	1					D2589	KEYS, KEY CHAIN
1	1	1							D2985	DECAL
1	1	1			1	1	1		D3015-3	LOCK NUT
			1		1				D3186-3	SPACEPOD DOOR, LH
				1		1			D3186-4	SPACEPOD DOOR, RH
1**		1**							D3187-1	FLOOR
	1**								D3187-2	FLOOR
1									D3188-5	SPACEPOD BODY
	1								D3188-6	SPACEPOD BODY
		1							D3188-7	SPACEPOD BODY
1	1	1			1	1	1		D3547-1	BRACKET
1	1	1			1	1	1		D3550-1	STRUT
			1	1	1	1	1		D3552-7	GAS SPRING
1	1	1			1	1	1		D3554-7	BALL STUD
8	8	8							AN3-3A	BOLT
2	2	2							AN3-10A	BOLT
8	8	8							AN3H4	BOLT
1	1	1			1	1	1		AN5-5A	BOLT
36	36	36							AN525-10R7	SCREW
8	8	8			4	4	4		AN526C832R14	SCREW
7	7	7							MS24694S67	SCREW
1	1	1			1	1	1		MS24694S69	SCREW
			2	2	2	2	2		MS27039-0811	SCREW
8	8	8			1	1	1		AN3235-020-935	WASHER
8	8	8							AN960JD10	WASHER
16	16	16			1	1	1		AN960JD10L	WASHER
			4	4	8	8	8		AN960JD8	WASHER
3	3	3			3	3	3		AN960JD516	WASHER
			2	2	2	2	2		NAS1515H3	NYLON WASHER
			2	2	6	6	6		MS21042L08	NUT
16	16	16			1	1	1		MS21042L3	NUT, (or MS21042-3)
1	1	1			1	1	1		MS21042L5	NUT
16	16	16							AKS7-1032-130	INSERT
28**	28**	28**							AKS7-1032-130	INSERT
								3	M81824/1-2	SPLICE

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Revision: E

Date: 09.07.31

REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D350-600

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-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
								2	D3597-1	FEMALE SPADE CONNECTOR
								1	D3598-2-096	EXPANDABLE SLEEVE
								24	D3599-1	TIE-WRAP
								24	D3600-1	TIE-WRAP MOUNT
								24 FT	M22759/16-22-9	WIRE
			1*	1*	1*	1*			D2464-1250	NEOPRENE SEAL
1**		1**	1*		1*				D3567-1	DECAL
	1**			1*		1*			D3567-2	DECAL
			2*	2*					D2586	LATCH
			2*	2*					D2585	MOUNTING CHANNEL
			2*	2*					D2621	LATCH PLATE
			2*	2*					MS27039-1-15	SCREW
					2	2	1		MS27039-1-25	SCREW
			2*	2*	2	2	1		AN960JD10	WASHER
			2*	2*	2	2	1		MS21042L3	NUT (or MS21042-3)
			1*	1*					D2857-1	HINGE BRACKET
			1*	1*					D2857-2	HINGE BRACKET
			2*	2*					D2228	BACKING PLATE
			8*	8*	8	8	8		AN526C832R10	SCREW
			8*	8*	8	8	8		AN960JD8	WASHER
			8*	8*	8	8	8		MS21042L08	NUT
			1*	1*	1*	1*	1		D3557-1	BRACKET
			2*	2*	2*	2*	2		D2228	BACKING PLATE
			1*	1*	1*	1*	1		D3554-7	BALL STUD
			1*	1*	1*	1*	1		AN960JD516	WASHER
			1*	1*	1*	1*	1		D3015-3	LOCK NUT
			2*	2*	2*	2*	2		AN526C832R14	SCREW
			2*	2*	2*	2*	2		AN526C832R10	SCREW
			4*	4*	4*	4*	4		AN960JD8	WASHER
			4*	4*	4*	4*	4		MS21042L08	NUT
2**	2**	2**			1	1	1		D2237	STRIKER PLATE
4**	4**	4**			2	2	2		MS20426AD4-5	RIVET
2**	2**	2**			2	2	2		D3538-1	HINGE BRACKET
2**	2**	2**							D2179	HINGE BRACKET PLATE
4**	4**	4**			4	4	4		AN526C832R24	SCREW
4**	4**	4**			4	4	4		AN960JD8	WASHER
4**	4**	4**			4	4	4		MS21042L08	NUT

* PRE-INSTALLED ON D3186-3/-4 SPACEPOD™ DOOR

** PRE-INSTALLED ON D3188-5/-6/-7 SPACEPOD™

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Revision: E
Date: 09.07.31